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DART AEROSPACE LTD	Work Order:	24296
Description: Arm	Part Number:	D2802-1
Dwg: D2802 rev.A	Qty:	6

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue W/O	W	05.09.15	6
2	METAL	Cut blanks 15.800" long 1.7500" Material: 6061-T6 bar 6.00" x 0.50" Batch: M18463	W	05.09.15	6
3	HAAS	Machine as per folio FA101	SD	05.09.21	6
4	CNC-CELL	Counter sink .375 dia as per dwg	SD	05.09.21	6
5	QC	Inspect Level 2	SD	05.09.21	6
6	QC	Inspect Level 8	SD	05.09.21	6
7	METAL	Tumble & Deburr NO sharp edges.	W	05.09.27	6
8	QC	Inspect Level 5	W	05.09.27	6
9	FINISHING	Chemical conversion coat as per QSI 005 4.3	N/A		
10	STORES	Identify and stock	PD	05.09.27	6
11	EXPEDITING	Close W/O Inspect level 21 Cost / part: 43.54 545 05/09/29	W	05.09.29	6

Rev	Date	Change	Revised By	Approved
A	00.11.06	New Issue	EC	
B	02.03.18	Re-format	NG	02-03-18

RELEASED

02/03/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
	2	As shown	JM	05-09-19		JB 05-09-19	JB 05-09-27
05-09-27	9	Parts going directly from CNC to welding. onto steps. D412-630-013 D412-630-013	AD	05-09-27	6		2 05-09-27

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/09/21	3	-Baseplate moved in vice, vice	JB 05-09-21	Scrub parts replace	SD 05-09-21	2 05-09-27	JB 05-09-21	2 05-09-21

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: SD Date: 05/09/28

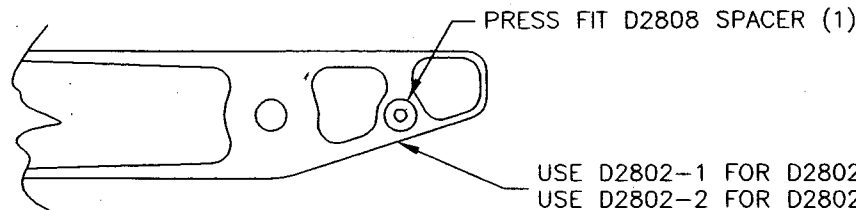
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

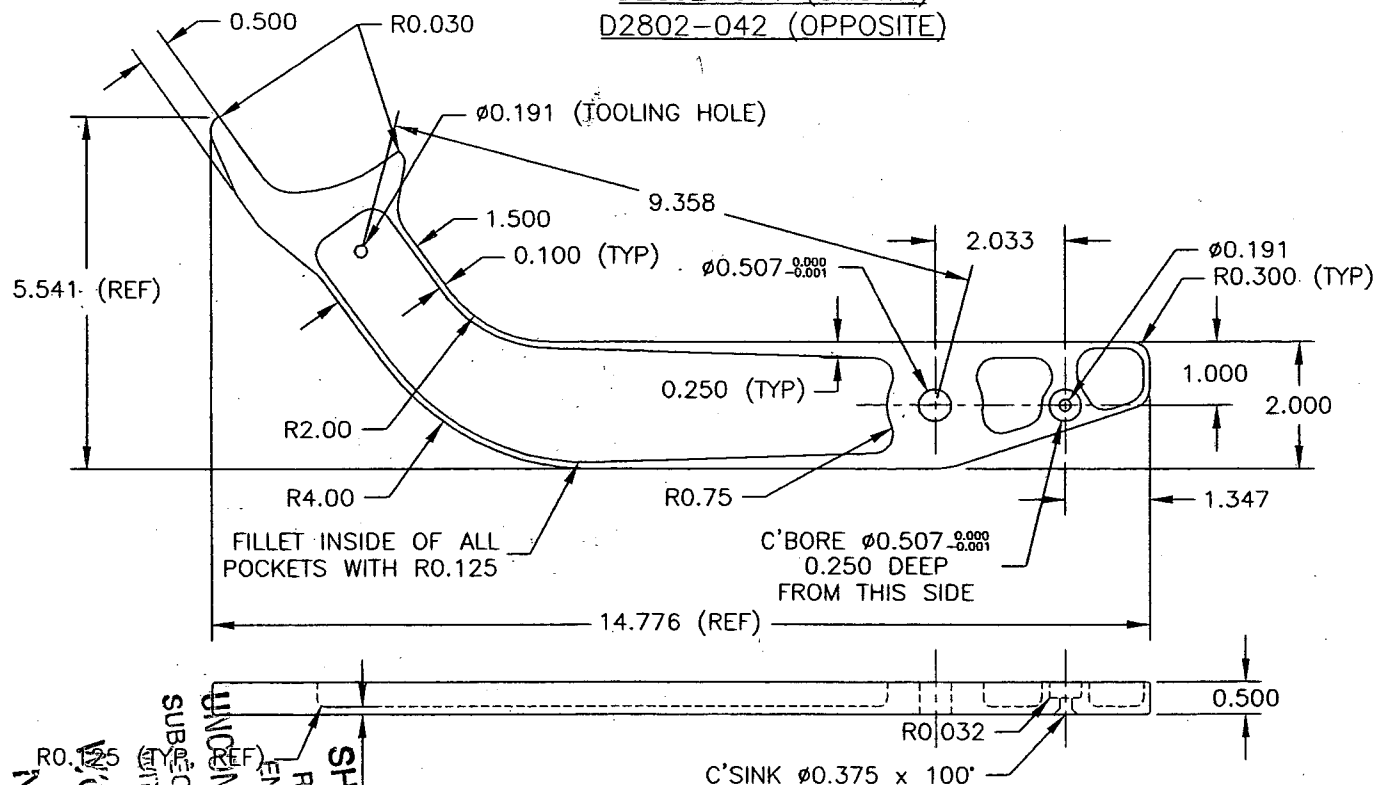


DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>CP</i>	APPROVED <i>CH</i>	HAWKESBURY, ONTARIO, CANADA
DATE 00.11.03	TITLE ARM	DRAWING NO. D2802
A	00.11.03	NEW ISSUE
REV. A	SHEET 1 OF 1	SCALE 1:3

RELEASED
00.11.13



D2802-041 (SHOWN)
D2802-042 (OPPOSITE)



D2802-1 (SHOWN)
D2802-2 (OPPOSITE)

SHOP COPY
RETURN TO
ENGINEERING
UNLESS ROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 24246

MACHINE PER DRAWING FILE "D2802-A1.DWG"
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK (REF)
DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 15, 2005
10:56 am

Work Order No : 0024296
Project Name : D2802-1
Project For : WK539
Work Order Type : Main
Main WO Number :
House Part Number : D2802-1
Description : Arm
Manufactured : Yes
Amount Req'd : 6
Amount Done : 0
Start Date : 09-15-05
Est Finish Date : 09-30-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order: 24296
Description: -		Part Number: 02802-1
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.500	$\pm .010$.502	/			
Ø .191	$\pm .005$ $\pm .001$.191	/			
1.500	$\pm .010$	1.501	/			
.100	$\pm .010$.102	/			
Ø .507	$\pm .001$.5073	/			
.250	$\pm .010$.251	/			Taper
2.033	$\pm .010$	2.033	/			
Ø .191	$\pm .005$ $\pm .006$	Ø .191	/			
R.300	$\pm .010$	R.300	/			
1.000	-	1.005	/			
2.000	-	2.001	/			
Ø .507						
Ø .507		Ø .5074	/			
.250 Deep	$\pm .010$.255	/			
Ø .507						
R.125	$\pm .010$	R.125	/			
.500	$\pm .010$.5002	/			
.125	$\pm .010$.128	/			
Ø .375x100°	$\pm .010$.375	✓			

Measured by: SA	Audited by: PK	Prototype Approval:
Date: 05.09.21	Date: 05.09.21	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	